

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003279**Date Inspected:** 09-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yanhua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) Inspector Roscoe Dixon was present at the time requested to randomly observe welding and associated operations being performed for the Orthotropic Box Girders (OBG).

**Bay 3 – Heavy Duty Machinery Shop**

The QA Inspector observed ZPMC qualified welder Dong Hu Yong Cang ID 203805 utilizing WPS-345-FCAW-2G (2F) Repair to perform Flux Core Arc Welding (FCAW) repairs of deck panel Partial Joint Penetration (PJP) welds on DP076-001.

The QA Inspector observed ZPMC personnel performing general grinding on deck panel repair welds of DP066-001, DP073-001, and DP076-001.

The QA Inspector located and inventoried the 21 deck panels in New Tower Building Bay #3

The welding in progress generally appeared to conform to contract specifications.

**Bay 1 – OBG Shop**

The QA Inspector observed Mr. Cai Xin Xin of ZPMC performing Magnetic Particle Testing (MT) on deck panel DP088-001, a total of 81 cracks were found during the initial MT testing. The cracks were removed with a grinder and another MT test was performed.

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Mr. Xin informed the QA Inspector that no indications were found during the second MT inspection.

The QA Inspector observed deck panel DP358-001 idle at Gantry #1 (SAW) welding was completed, DP439-001 and DP142-001 were idle at Gantry #2 and (SAW) welding was completed.

For more detail see photographs shown below:



### Summary of Conversations:

As noted within the report shown above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dixon,Roscoe	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer

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